

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D212-803 REV. D AND INSTRUCTIONS
FOR CONTINUED AIRWORTHINESS ICA-D212-803 REV. 3 OR LATER APPROVED REVISIONS

REF. FAA STC: SR02233SE
REF. TCCA STC: SH16-34
REF. EASA STC: EASA.IM.R.S.10048356

1.0 PURPOSE

It has come to Dart's attention that because of variations in travel and alignment, the p/n D4410-041/-043/-045, D5046-041/-043/-045/-047 and D5155-041/-043/-045/-047 Collective Heads used in the DXXX-803-XXX LH PIC kits may interfere with the OEM LH crew door at the bottom of their travel.

The purpose of this DSI is to provide instructions for modifying the OEM LH crew door to provide clearance to prevent that possible interference.

2.0 PROCEDURE

With reference to Figures 1 and 2, modify the OEM LH crew door as follows:

Note: De-riveting parts may increase ease of trimming fabrication and installation of new parts.

- 2.1 Trim inner door skin from the forward rib to the dimensions shown in Figure 1. Take care not to damage rib.
- 2.2 Fabricate a cover (1) from 0.040" thick 2024-T3 aluminum per QQ-A-250/5 to close the inner skin.
- 2.3 Fabricate inner angle (2) from 0.040" thick 2024-T3 aluminum per QQ-A-250/5 or 0.040" thick 2024-T3 aluminum extruded angle per QQ-A-200/3 to attach the cover (1) to top frame as shown in Figures 1 and 2.
- 2.4 Transfer existing 7x ϕ 0.129" (#30 drill) rivet holes from the top frame to the new inner angle (2) as shown in Figure 2.
- 2.5 Pitch 5x ϕ 0.129" (#30 drill) rivet holes as required, approximately 1.0" -1.1" pitch, from cover (1) to the inner angle (2) as shown in Figures 1 and 2.
- 2.6 Pitch 6x ϕ 0.129" (#30 drill) rivet holes as required, approximately 1.0"-1.1" pitch, from the inner door skin into the cover (1) as shown in Figure 1.
- 2.7 Pitch 7x ϕ 0.129" (#30 drill) rivet holes as required, approximately 1.0"-1.1" pitch, from the inner door skin into the cover (1) as shown in Figure 1.
- 2.8 Deburr and touch-up cutout and holes in OEM LH crew door with Alodine 1200/1201 per MIL-C-5541. Alodine parts (1) and (2) using Alodine 1200/1201 per MIL-C-5541. Prime parts (1) and (2) per the Aircraft Maintenance Manual as required prior to installation.
- 2.9 Rivet parts (1) and (2) together using CR3213-4 or equivalent rivets.
- 2.10 Seal the gap opening near the bottom of the cover (1) using Pro Seal 890 or equivalent (3).
- 2.11 Touch up paint on the door per Aircraft Maintenance Manual.

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A	NEW ISSUE, REF PAR17-582	RF	17.10.23
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9791	SHEET 1 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	ALTERATION OEM LH DOOR	NTS
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3.0 WEIGHT AND BALANCE

This DSI has a negligible effect on Weight & Balance.

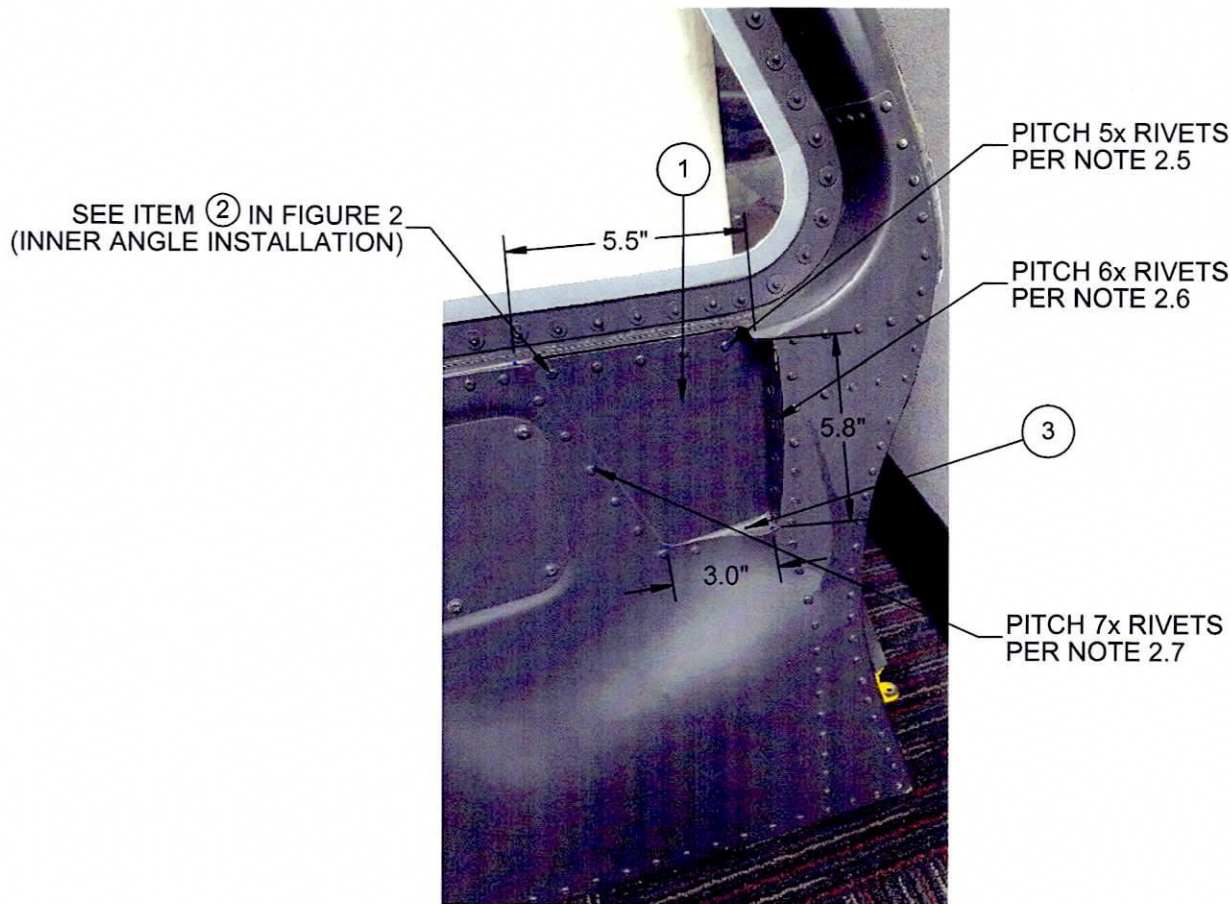


FIGURE 1 - Door Modification for Co-Pilot Collective Head Installation
OEM LH Crew Door

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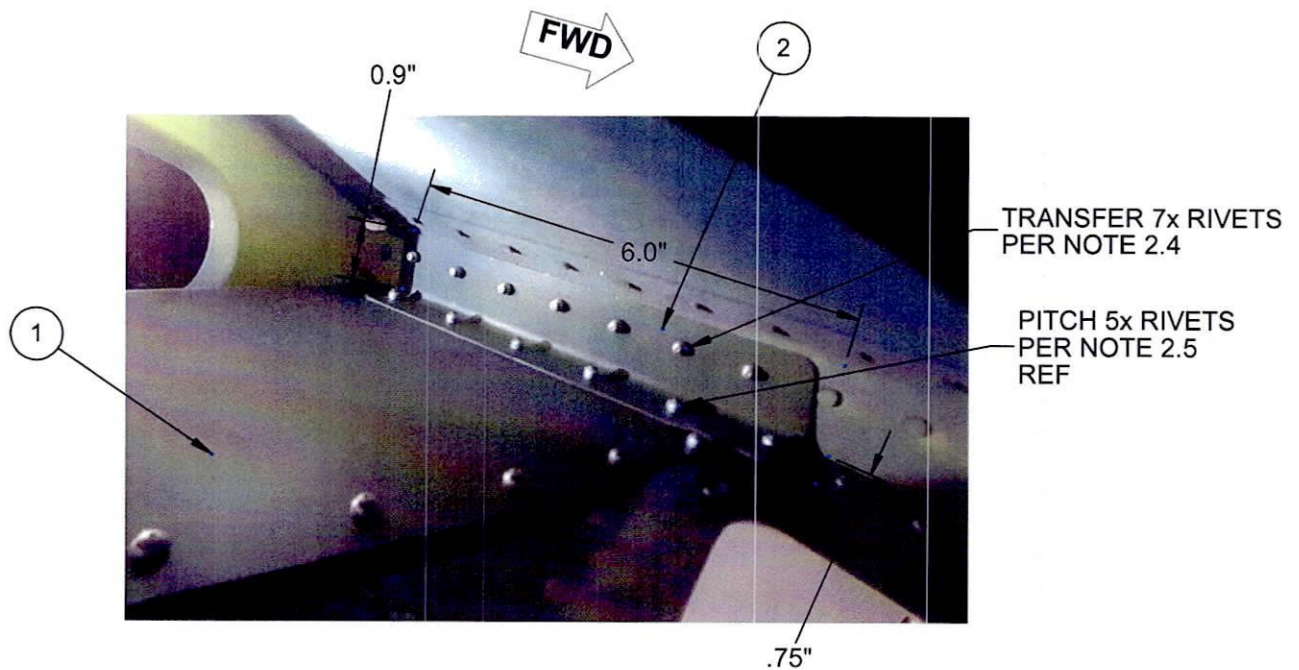


FIGURE 2 - Inner Angle Installation
OEM LH Crew Door

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